FIG. 1

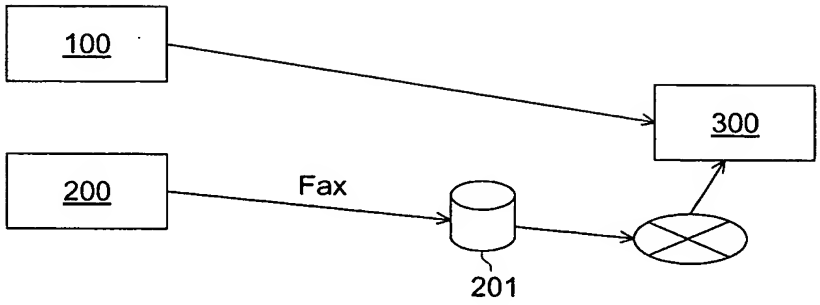

FIG. 2

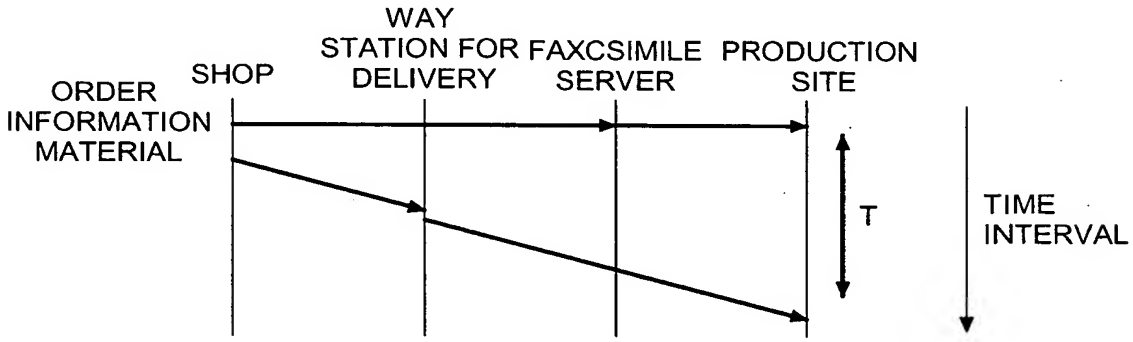

FIG. 3

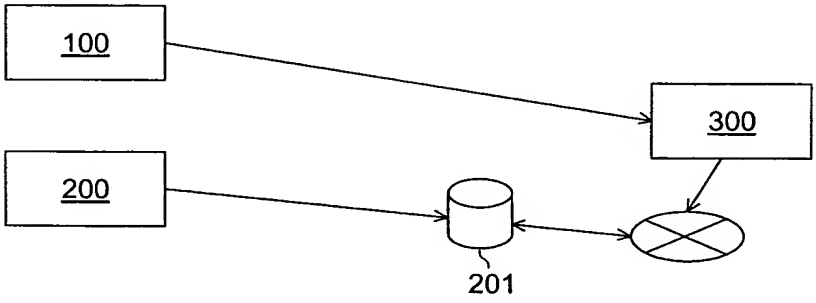

FIG. 4

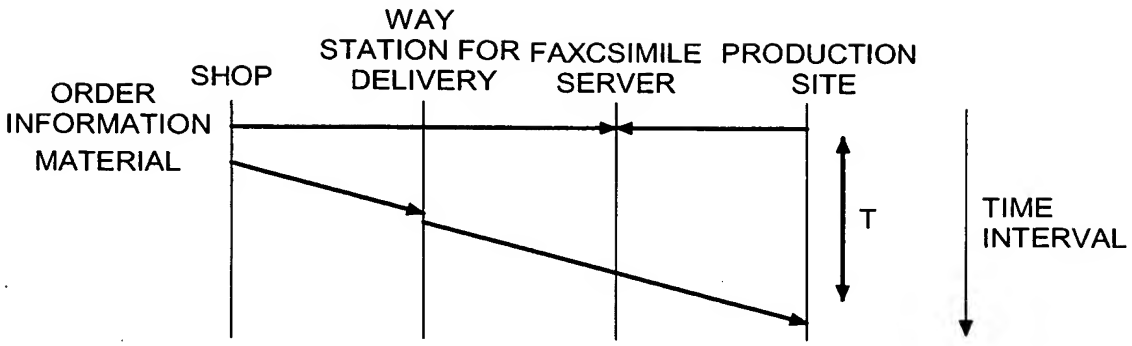

FIG. 5

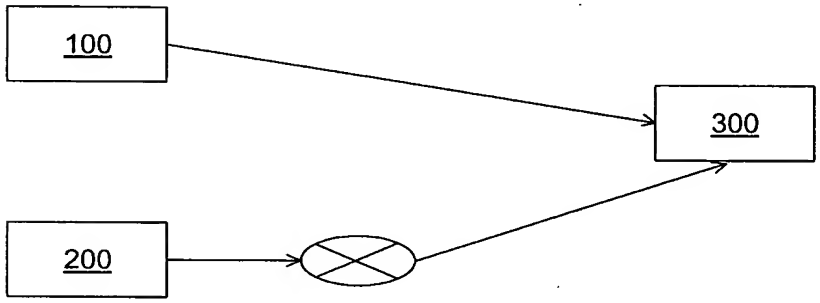

FIG. 6

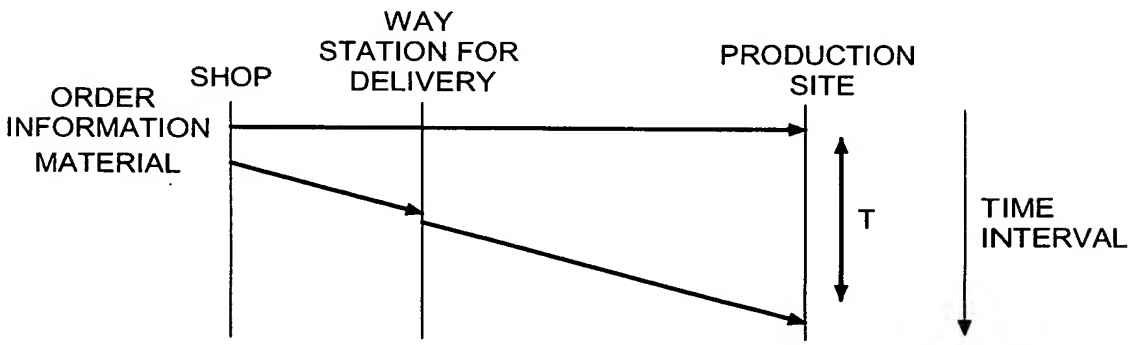

FIG. 7

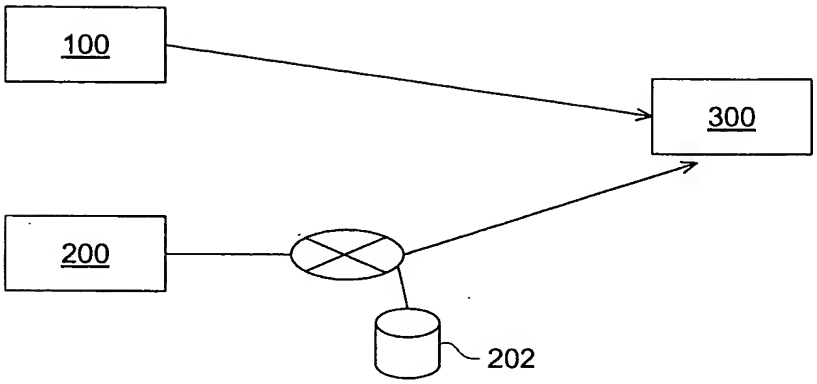

FIG. 8

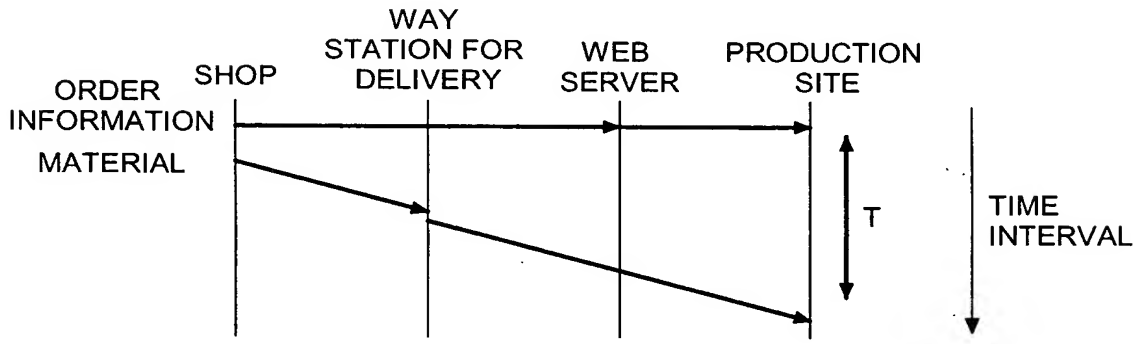

FIG. 9

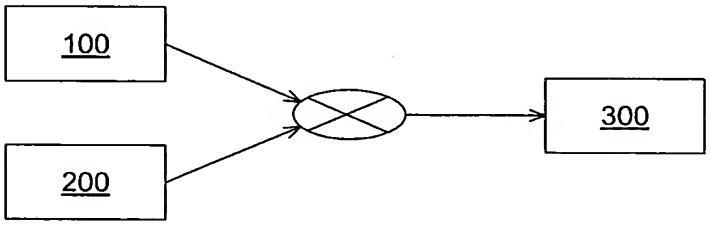

FIG. 10

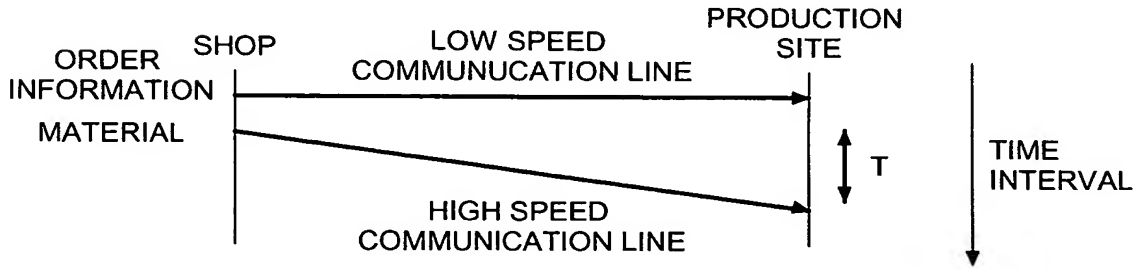

FIG. 11

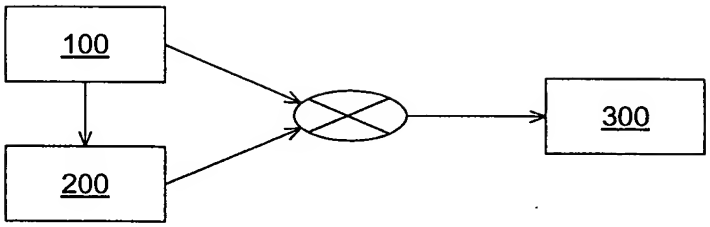

FIG. 12

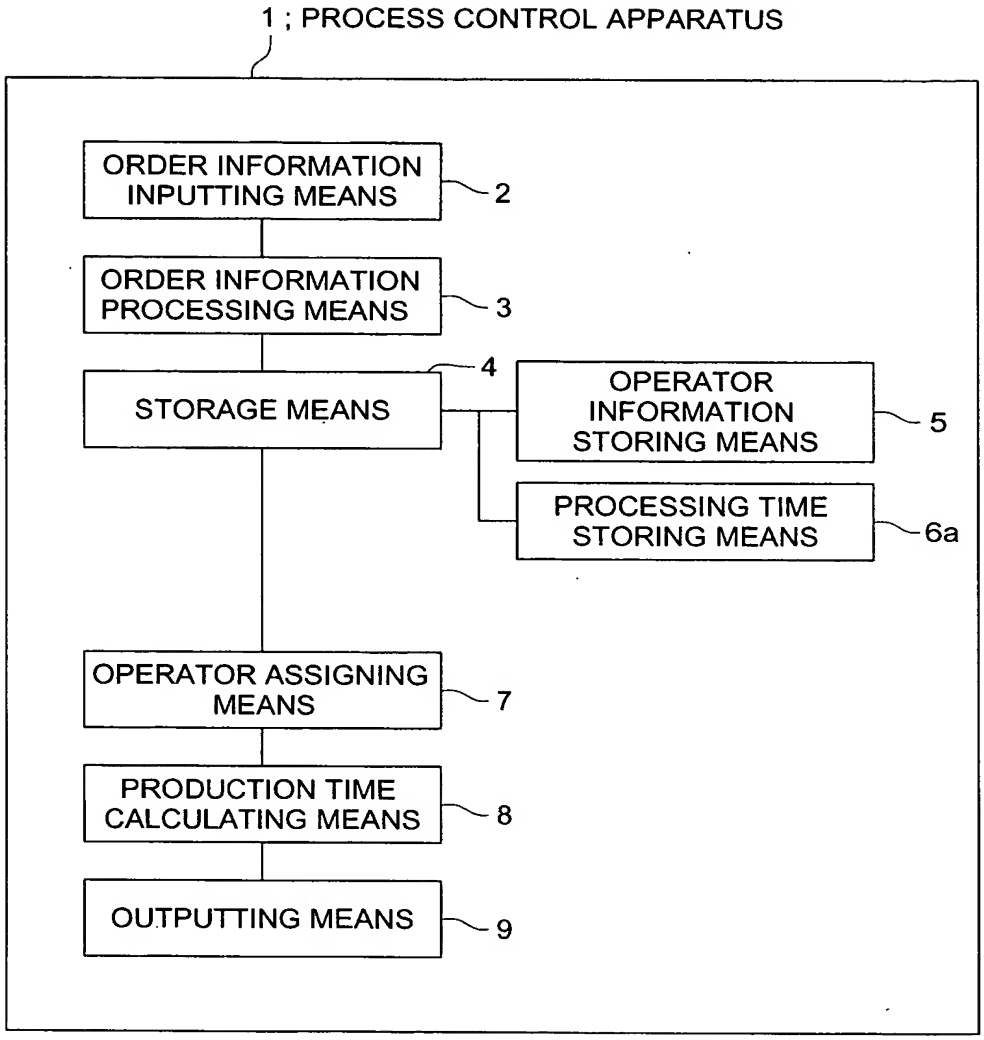
1 ; PROCESS CONTROL APPARATUS
ORDER INFORMATION INPUTTING MEANS
2
ORDER INFORMATION PROCESSING MEANS
3
4
STORAGE MEANS
OPERATOR INFORMATION STORING MEANS
5
PROCESSING TIME STORING MEANS
6a
OPERATOR ASSIGNING MEANS
7
PRODUCTION TIME CALCULATING MEANS
8
OUTPUTTING MEANS
9

FIG. 13

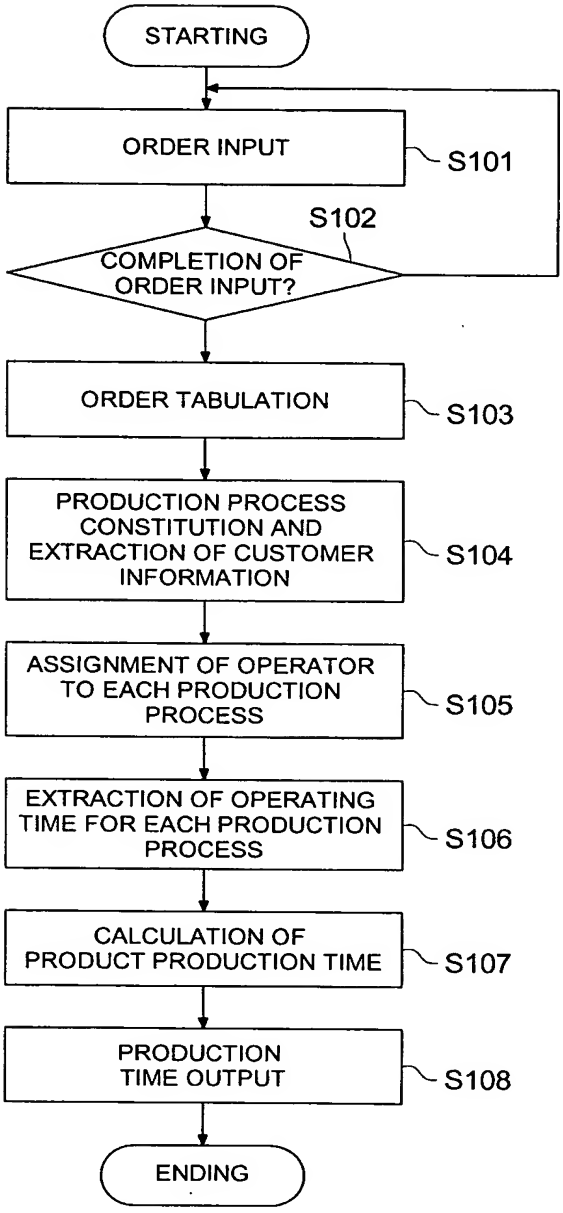
STARTING
ORDER INPUT
S101
S102
COMPLETION OF ORDER INPUT?
ORDER TABULATION
S103
PRODUCTION PROCESS CONSTITUTION AND EXTRACTION OF CUSTOMER INFORMATION
S104
ASSIGNMENT OF OPERATOR TO EACH PRODUCTION PROCESS
S105
EXTRACTION OF OPERATING TIME FOR EACH PRODUCTION PROCESS
S106
CALCULATION OF PRODUCT PRODUCTION TIME
S107
PRODUCTION TIME OUTPUT
S108
ENDING

FIG. 14

10 ; OPERATOR ASSIGNING TABLE

CUSTOMER A

PRODUCTION PROCESS / PRODUCT	PRODUCTION PROCESS 1	PRODUCTION PROCESS 2	
PRODUCT 1	OPERATOR a	OPERATOR a	
PRODUCT 2	OPERATOR b	OPERATOR c	
PRODUCT 3	OPERATOR a	OPERATOR d	

FIG. 15

11a ; PROCESSING TIME ASSIGNING TABLE

PRODUCTION PROCESS / OPERATOR	PRODUCT 1 PRODUCTION PROCESS 1	PRODUCT 1 PRODUCTION PROCESS 2	
OPERATOR a	2 HOURS	1 HOUR	
OPERATOR b	3 HOURS	2 HOURS	
OPERATOR c	3 HOURS	2 HOURS	
OPERATOR d	4 HOURS	3 HOURS	

FIG. 16

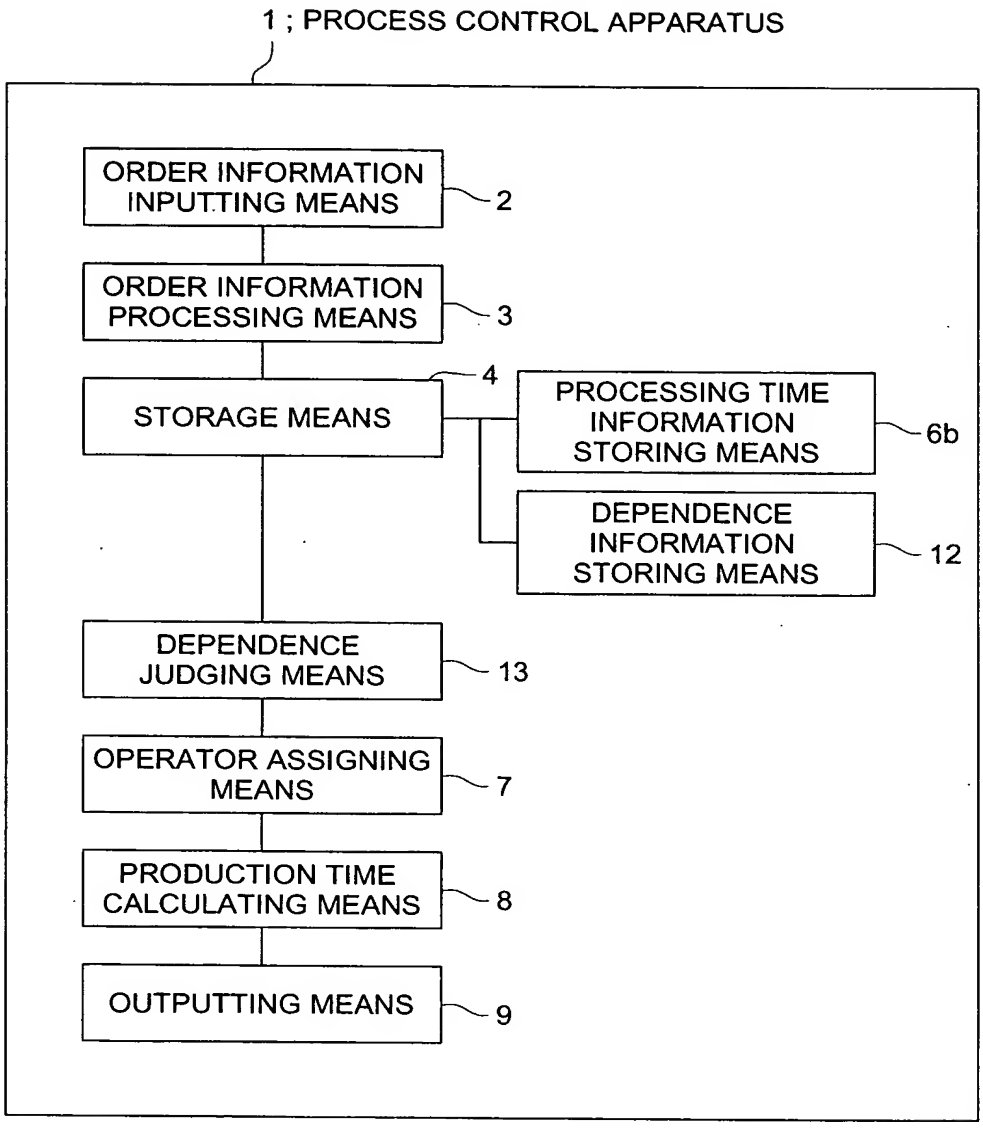
1 ; PROCESS CONTROL APPARATUS
ORDER INFORMATION INPUTTING MEANS
2
ORDER INFORMATION PROCESSING MEANS
3
4
STORAGE MEANS
PROCESSING TIME INFORMATION STORING MEANS
6b
DEPENDENCE INFORMATION STORING MEANS
12
DEPENDENCE JUDGING MEANS
13
OPERATOR ASSIGNING MEANS
7
PRODUCTION TIME CALCULATING MEANS
8
OUTPUTTING MEANS
9

FIG. 17

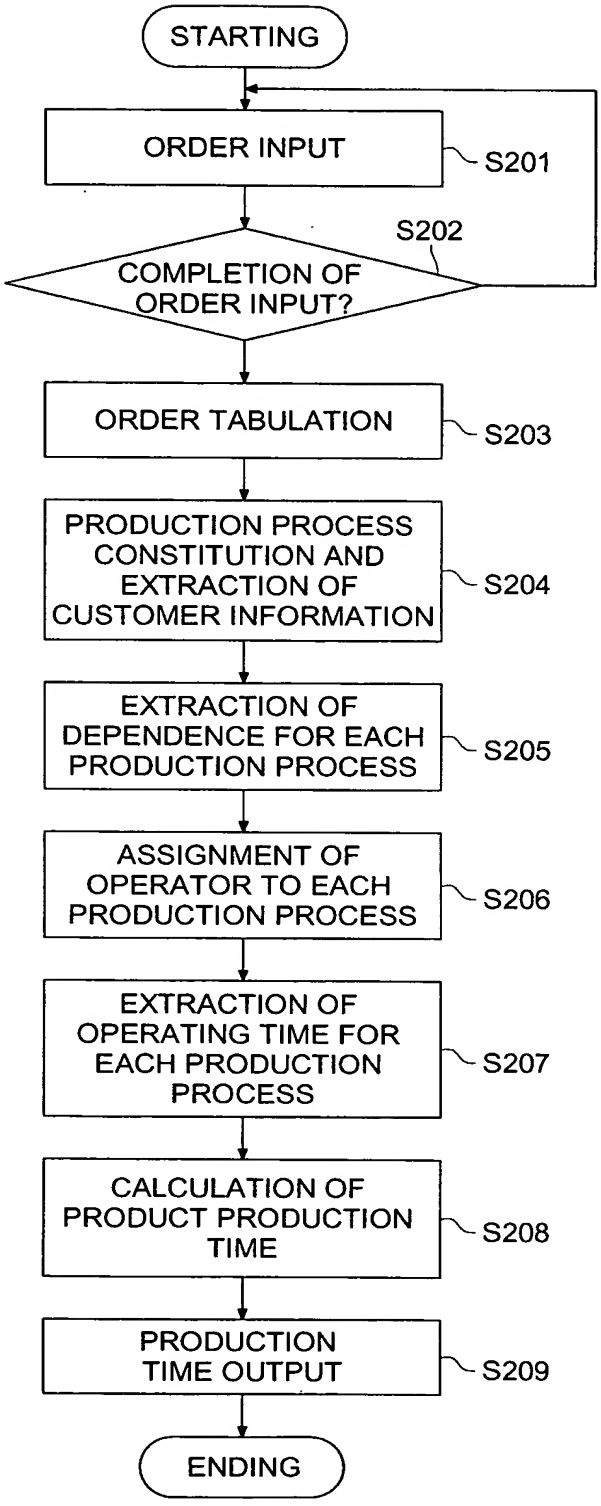
STARTING
ORDER INPUT
S201
S202
COMPLETION OF ORDER INPUT?
ORDER TABULATION
S203
PRODUCTION PROCESS CONSTITUTION AND EXTRACTION OF CUSTOMER INFORMATION
S204
EXTRACTION OF DEPENDENCE FOR EACH PRODUCTION PROCESS
S205
ASSIGNMENT OF OPERATOR TO EACH PRODUCTION PROCESS
S206
EXTRACTION OF OPERATING TIME FOR EACH PRODUCTION PROCESS
S207
CALCULATION OF PRODUCT PRODUCTION TIME
S208
PRODUCTION TIME OUTPUT
S209
ENDING

FIG. 18

14 ; DEPENDENCE ASSIGNING TABLE

PRODUCTION PROCESS / PRODUCT	PRODUCTION PROCESS 1	PRODUCTION PROCESS 2	
PRODUCT 1	EQUIPMENT	OPERATOR	
PRODUCT 2	OPERATOR	OPERATOR	
PRODUCT 3	EQUIPMENT	EQUIPMENT	

FIG. 19

11b ; PROCESSING TIME ASSIGNING TABLE

PRODUCTION PROCESS / PRODUCT	PRODUCTION PROCESS 1	PRODUCTION PROCESS 2	
PRODUCT 1	1 HOUR	2 HOURS	
PRODUCT 2	4 HOURS	3 HOURS	
PRODUCT 3	2 HOURS	2 HOURS	